



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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D130-1048-014
Job Sheet 196759



Part No: D130-1048-014

Job Qty: 1 pcs

Part Name: H130/EC130 - Skidtube - Standard w/ Full-Length Wearplates - RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/20/19

Job Tracking No:

Due Date: 7/12/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D130-1048-014 REV.A/ IIN-D130-1048 REV.C IPP REV:A 19.06.20 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Handfinish - 4 - Assembly	1 pcs	7/12/19	7/12/19	0.00	0.50	Handfinish - 4 - 1		419-7-17
							Handfinish - 4 - 10		
							Handfinish - 4 - 11		
							Handfinish - 4 - 12		
							Handfinish - 4 - 13		
							Handfinish - 4 - 14		
							Handfinish - 4 - 15		
							Handfinish - 4 - 2		
							Handfinish - 4 - 3		
							Handfinish - 4 - 4		
							Handfinish - 4 - 5		
							Handfinish - 4 - 6		
							Handfinish - 4 - 7		
							Handfinish - 4 - 8		
							Handfinish - 4 - 9		
120	QC 5	1 pcs	7/12/19	7/12/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		

DART AEROSPACE
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CANADA
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Container No: S198687

Part: D130-1048-014
Job No: 196759
Serial No/Batch: S198687
Revision: C/A
Inspector:
Exp Date:
Instructions: TC STC SH19-4 Issue 1, FAA STC SR04320N

130 Packaging 1-1 - Pick Kit - B4B 1 pcs	7/12/19	0.00 0.00	QC 5 - 40	JUL 17 2019
			Packaging 1 - 1 - B4B	
			Packaging 1 - 2 - B4B	
			Packaging 1 - 3 - B4B	
			Packaging 1 - 4 - B4B	
			Packaging 1 - 5 - B4B	
			Packaging 1 - 6 - B4B	
			Packaging 1 - 7 - B4B	
			Packaging 1 - 8 - B4B	
			Packaging 1 - 9 - B4B	
			Packaging 1 - 10 - B4B	
			Packaging 1 - 11 - B4B	
			Packaging 1 - 12 - B4B	
			Packaging 1 - 13 - B4B	
			Packaging 1 - 14 - B4B	
			Packaging 1 - 15 - B4B	
			Packaging 1 - 16 - B4B	
			Packaging 1 - 17 - B4B	
			Packaging 1 - 18 - B4B	
			Packaging 1 - 19 - B4B	
			Packaging 1 - 20 - B4B	
			Packaging 1 - 21 - B4B	
			Packaging 1 - 22 - B4B	
			Packaging 1 - 23 - B4B	JUL 17 2019
			Packaging 1 - 24 - B4B	
			Packaging 1 - 25 - B4B	
			Packaging 1 - 26 - B4B	
			Packaging 1 - 27 - B4B	
			Packaging 1 - 28 - B4B	
			Packaging 1 - 29 - B4B	
			Packaging 1 - 30 - B4B	
			Packaging 1 - 31 - B4B	
			Packaging 1 - 32 - B4B	
			Packaging 1 - 33 - B4B	
			Packaging 1 - 34 - B4B	
			Packaging 1 - 35 - B4B	
			Packaging 1 - 36 - B4B	
135 QC 4 1 pcs	7/12/19	0.00 0.00	QC 4 - 28	
			QC 4 - 58	
			QC 4 - 69	
			QC 4 - 9	
			QC 4 - 46	
			QC 4 - 68	
			QC 4 - 72	JUL 17 2019
			QC 4 - 74	
			QC 4 - 75	
140 Packaging 3-1 - Stock - B4B 1 pcs	7/12/19	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	JUL 17 2019
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	

					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
155 DC - 1 - B4B	1 pcs	7/12/19	0.00 0.00	DC - 1 - B4B		JUL 17 2019
				DC - 2 - B4B		
165 QC 21 - SA	1 pcs	7/12/19	0.00 0.00	QC 21 - SA - 21		JUL 17 2019
				QC 21 - SA - 70		
				QC 21 - SA - 53		

DAS
70
9-89

Part Op 110 - ASSEMBLE AS PER DWG SEE DWG NOTES 9) TORQUE BOLT TO 15 - 25 in-lbs 10) TORQUE NUT TO 44 - 62
Descriptions: in-lbs 11) TORQUE NUT TO 62 - 71 in-lbs 12) SEAL FAYING SURFACES WITH SIKAFLEX-241/-291 13) FILLET SEAL
WITH SIKAFLEX-241/-291 14) PLUG SEAL SADDLE HOLES WITH SIKAFLEX-241/-291 SEALANT ENSURE SADDLE
BORE IS FREE OF SEALANT
120 - QC5- Inspect part completeness to step on W/O
130 - Pick Kit - BAG AND ID HARDWARE.
135 - QC4- 100% Inspect kits for completeness
140 - Identify and pack for shipping as per PPP D130-1048-014 Location: _____ PPP Rev: _____
155 - Document Control - Photocopy blue file and create labels as per PPP D130-1048-014 chg 001
165 - QC21- Final Inspection - Work Order Release

 DAS
 70
 9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
22201BC120090L	Bolt	1 Ea (1 ea)	110-Handfinish - 4 - Assembly	5194791
23111AG120LE	Washer	1 Ea (1 ea)	110-Handfinish - 4 - Assembly	5101932
AN8C56A	Bolt	3 Ea (3 ea)	110-Handfinish - 4 - Assembly	5107026
ASN52320BH120N	Nut	1 Ea (1 ea)	110-Handfinish - 4 - Assembly	5105104
D130-1048-042	H130/EC130 - Replacement Skidtube - Standard - RH	1 pcs (1 ea)	110-Handfinish - 4 - Assembly	5116632
D130-1048-052	H130/EC130 - Wearplates - DART & OEM Replacement - Basic - RH	1 pcs (1 ea)	110-Handfinish - 4 - Assembly	5197983
D130-1048-053	H130/EC130 - Wearplates - DART & OEM Replacement - Midtube	1 pcs (1 ea)	110-Handfinish - 4 - Assembly	195800
D5569-3/1	Replacement Blade - Basic Aluminum	1 pcs (1 ea)	110-Handfinish - 4 - Assembly	5144472
D5570-1	Blade Plug	1 pcs (1 ea)	110-Handfinish - 4 - Assembly	5102643
D5594-1	GH Bushing	6 pcs (6 ea)	110-Handfinish - 4 - Assembly	5129352
D5594-3	GH Washer	6 pcs (6 ea)	110-Handfinish - 4 - Assembly	5104022
NAS1149C0832R	Washer (AN960C816L)	3 Ea (3 ea)	110-Handfinish - 4 - Assembly	50760142
NAS1291C8	Nut, Self-Locking	3 Ea (3 ea)	110-Handfinish - 4 - Assembly	5122909
23111AG100LE	Washer	1 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	5196062
ASNA0045BC100L	Nut, Castellated	1 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	5109874
DHS411-101.3106	Metric Hex Head Aerospace Bolt	1 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	5093539
MS21141S-06-05	Rivet	20 Ea (20 ea)	130-Packaging 1-1 - Pick Kit - B4B	5123451
MS24665-231	Cotter Pin	1 pcs (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	F113815

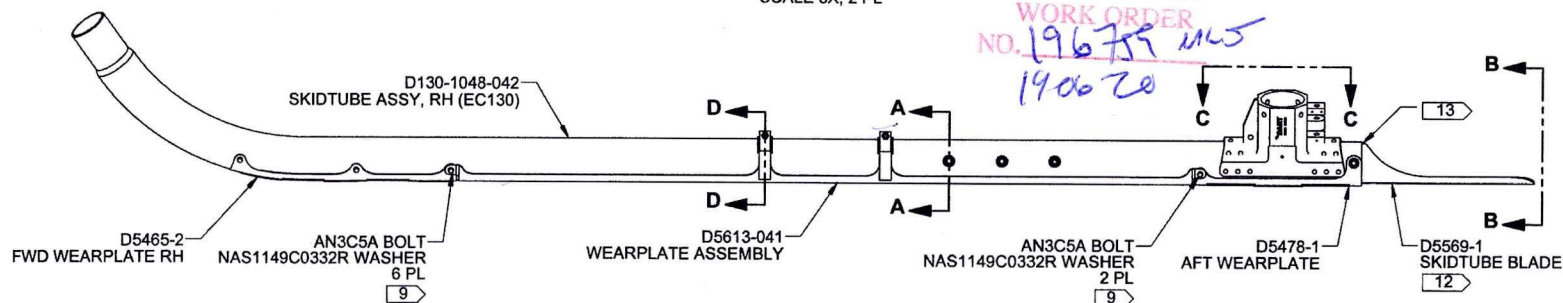
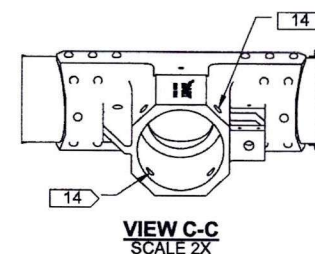
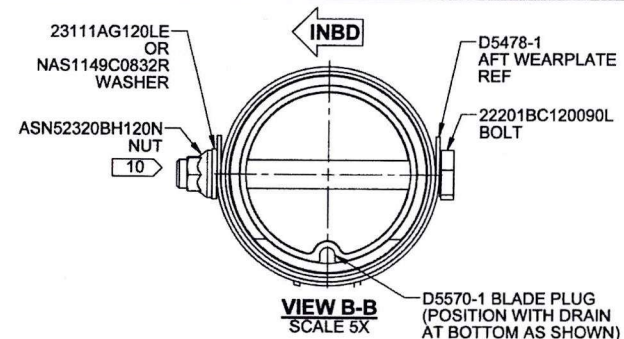
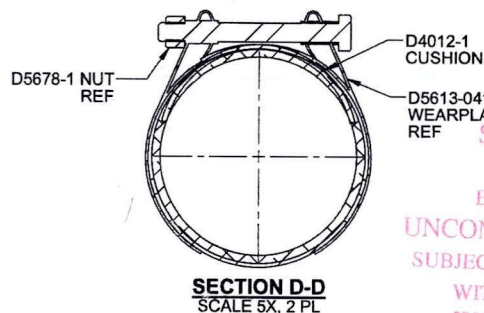
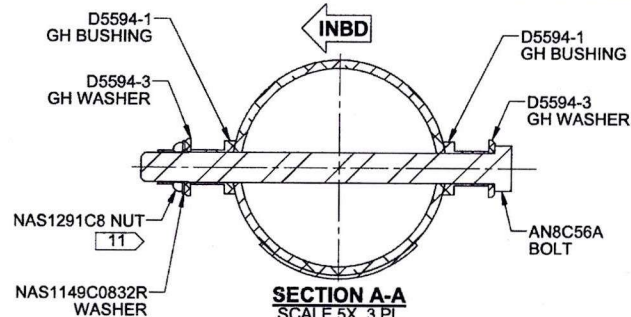
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Handfinish - 4 - Assembly	22201BC120090L	1	0	0
	23111AG120LE	1	40	0
	AN8C56A	3	18	0
	ASN52320BH120N	1	9	0
	D130-1048-042	1	0	0
	D130-1048-052	1	0	0
	D130-1048-053	1	0	0
	D5569-3/1	1	0	0
	D5570-1	1	4	0
	D5594-1	6	12	0
	D5594-3	6	15	0
	NAS1149C0832R	3	307	0
	NAS1291C8	3	32	0
	23111AG100LE	1	4	0
130-Packaging 1-1 - Pick Kit - B4B	ASNA0045BC100L	1	6	0
	DHS411-101.3106	1	4	0
	MS21141S-06-05	20	90	0
	MS24665-231	1	113	0

Part Specifications

Specifications could not be found.

QTY -014	P/N	DESCRIPTION
X	D130-1048-014	HEAVY DUTY SKIDTUBE INSTL, RH (EC130)
1	D130-1048-042	SKIDTUBE ASSY, RH (EC130)
2	D4012-1	CUSHION
1	D5465-2	FWD WEARPLATE RH
1	D5478-1	AFT WEARPLATE
1	D5569-1	SKIDTUBE BLADE
1	D5570-1	BLADE PLUG
6	D5594-1	GH BUSHING
6	D5594-3	GH WASHER
1	D5613-041	WEARPLATE ASSEMBLY
1	22201BC120090L	BOLT
1	23111AG120LE	WASHER (OR NAS1149C0832R)
8	AN3C5A	BOLT
3	AN8C56A	BOLT, MACHINE
1	ASN52320BH120N	NUT
8	NAS1149C0332R	WASHER
3	NAS1149C0832R	WASHER
3	NAS1291C8	NUT, SELF-LOCKING
1	23111AG100LE	WASHER (OR NAS1149C0732R)
1	ASNA0045BC100L	NUT, CATELLATED
1	DHS411-101.3106	BOLT
1	EN2367-18028	COTTER PIN (OR MS24665-231)
20	MS21141S0605	MAXIBOLT, BLIND, PAN HEAD (CR7621S06-05)



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: "TOTAL WEIGHT@D130-1048-012@D130-1048-01X.SLDASM" lbs
- 8) HARDWARE NOT SHOWN. TO BE SHIPPED LOOSE.
- 9) TORQUE BOLT TO 15 - 25 in-lbs
- 10) TORQUE NUT TO 44 - 62 in-lbs
- 11) TORQUE NUT TO 62 - 71 in-lbs
- 12) SEAL FAYING SURFACES WITH SIKAFLEX-241/-291
- 13) FILLET SEAL WITH SIKAFLEX-241/-291
- 14) PLUG SEAL SADDLE HOLES WITH SIKAFLEX-241/-291 OR PROSEAL 890 OR EQUIVALENT MIL-S-8802 SEALANT ENSURE SADDLE BORE IS FREE OF SEALANT

RELEASED

2019 JUN 19 NO
ECN19-625

APPROVED

A	NEW ISSUE	ZF	19.04.05
REV.	DESCRIPTION	BY	DATE
DESIGN	ZF		
DRAWN	ZF		
CHECKED	MW		
MFG. APPR.	JFS		
APPROVED	NO		
DE APPR.	CP		
DATE	19.04.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D130-1048-014** REV. A
SHEET 1 OF 1
TITLE **SKIDTUBE INSTL, RH (EC130)** SCALE NTS

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

32.16 PARTS LISTS

32.16.1 D130-1048-011/-012/-013/-014 Skidtubes

QTY -011	QTY -012	QTY -013	QTY -014	QTY -051	QTY -052	QTY -053	P/N	DESCRIPTION
X							D130-1048-011	BASIC SKIDTUBE INSTALLATION, LH
	X						D130-1048-012	BASIC SKIDTUBE INSTALLATION, RH
		X					D130-1048-013	HEAVY DUTY SKIDTUBE INSTALLATION, LH
			X				D130-1048-014	HEAVY DUTY SKIDTUBE INSTALLATION, RH
1		1		X			D130-1048-051 (2)(3)	REPLACEMENT WEARPLATES, LH
	1		1		X		D130-1048-052 (2)(3)	REPLACEMENT WEARPLATES, RH
		1	1			X	D130-1048-053 (3)	MIDTUBE WEARPLATE KIT
1		1					D130-1048-041	SKIDTUBE ASSY, LH
	1		1				D130-1048-042	SKIDTUBE ASSY, RH
				1			D5465-1	FWD WEARPLATE, LH
					1		D5465-2	FWD WEARPLATE, RH
				1	1		D5478-1	AFT WEARPLATE
						1	D5613-041	MIDTUBE WEARPLATE
				8	8		AN3C5A	BOLT
				8	8		NAS1149C0332R	WASHER
						2	D5678-1 (4)	NUT
						2	D4012-1	CUSHION
		1	1				D5569-1 (3)	HEAVY DUTY SKIDTUBE BLADE
1	1						D5569-3 (2)	SKIDTUBE BLADE
1	1	1	1				D5570-1 (2)(3)	BLADE PLUG
1	1	1	1				22201BC120090L (1)(2)(3)	BOLT
1	1	1	1				23111AG120LE (1)(2)(3)	WASHER (or NAS1149C0832R)
1	1	1	1				ASN52320BH120N (1)(2)(3)	NUT
6	6	6	6				D5594-1 (2)(3)	GH BUSHING
6	6	6	6				D5594-3 (2)(3)	GH WASHER
3	3	3	3				AN8C56A (2)(3)	BOLT
3	3	3	3				NAS1149C0832R (2)(3)	WASHER
3	3	3	3				NAS1291C8 (2)(3)	NUT
1	1	1	1				DHS411-101.3106 (1)	BOLT
1	1	1	1				23111AG100LE (1)	WASHER (or NAS1149C0732R)
1	1	1	1				ASNA0045BC100L (1)	NUT, CASTELLATED
1	1	1	1				EN2367-18028 (1)	COTTER PIN (or MS24665-231)
20	20	20	20				MS21141S0605	MAXIBOLT, BLIND, PAN HEAD (or CR7621S06-05)

- (1) Airbus Helicopter Part Numbers (or alternative) included in kit
 (2) Pre-assembled on D130-1048-011/-012 Skidtube
 (3) Pre-assembled on D130-1048-013/-014 Skidtube
 (4) Pre-assembled on D5613-041 Midtube Wearplate